

shf Apr 30 - T30AM

~~PRELIMINARY ISSUE~~

Work Order ID 83884

\*83884\*

Page 1

April-26-12 2:59:58 PM

Item ID: D412-785-003-403

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Pax Speaker Mount, Fwd

Start Date: 4/26/12 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D412-785-003-101

PC1 C

100

0.00

B12-4-27

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: petc

Prog Rev: pcu

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

B12-4-27

\*110\*

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

S. Schultz

(4)

**Work Order ID 83884**

April-26-12 2:59:58 PM

**\*83884\***

Page 2

Item ID: D412-785-003-403

Revision ID:

Item Name: Pax Speaker Mount, Fwd

Start Date: 4/26/12 Start Qty: 2.00

Required Date: 4/30/12 Req'd Qty: 2.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Small Fab

Memo

c'sink as per dwg

0.00

0.00

4X

d

PS 4/26/12

150

**\*150\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

5.264/30

(all)

160

**\*160\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

(4) 4/26/12 4-30

**Work Order ID 83884**

April-26-12 2:59:58 PM

**\*83884\***

Page 3

Item ID: D412-785-003-403

Revision ID:

Item Name: Pax Speaker Mount, Fwd

Start Date: 4/26/12 Start Qty: 2.00

Required Date: 4/30/12 Req'd Qty: 2.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC7-Inspect Chemical Conversion Coat

0.00

**\*170\***

QC

Memo

0.00

Quality Control

4X

m/l  
12/24/30

180

Identify as per dwg & Stock Location: 382

0.00

**\*180\***

Packaging

Memo

0.00

Packaging

C 4.2

12/24/30

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 12/24/30 AUTH h

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

m/l  
12-04-30

# Picklist Print

April-26-12 2:59:58 PM

Work Order ID: 83884

Parent Item: D412-785-003-403

Start Date: 4/26/12

Required Date: 4/30/12

Parent Item Name: Pax Speaker Mount, Fwd

Start Qty: 2.00

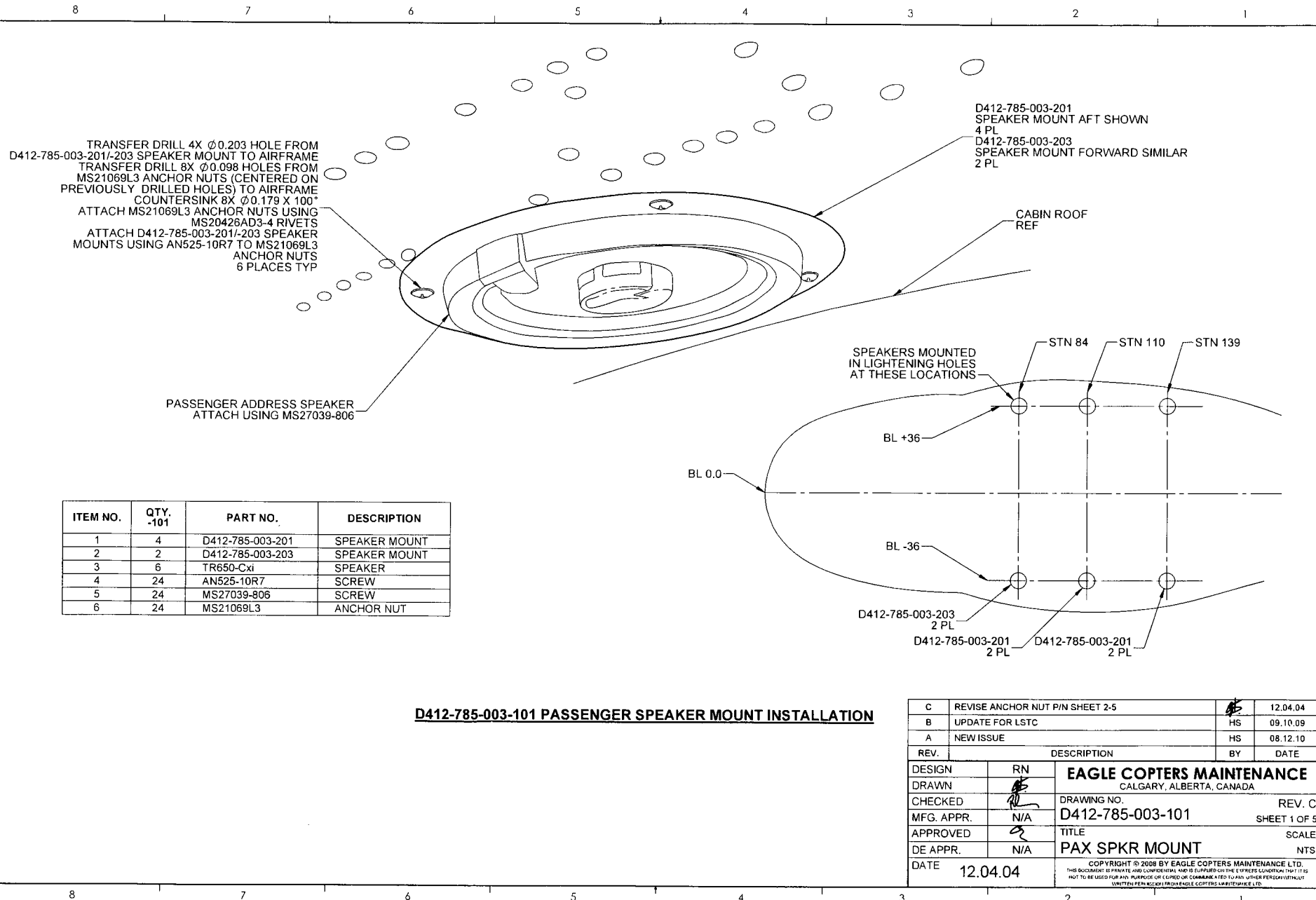
Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-09-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No				sf	226.1912		1.0526316	2	12-4-27	

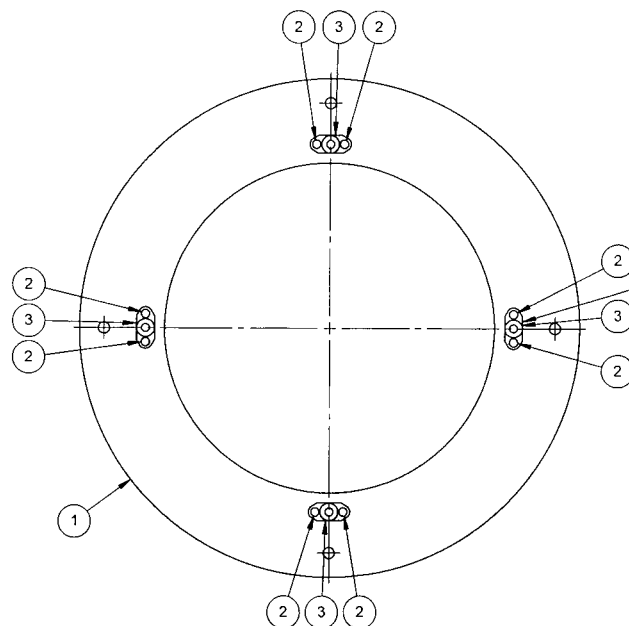
Location	Loc Qty	Loc Code
MAT022	226.1911626	
117684	21.318421	
120196	42.41	
120605	66.4627416	
121197	96	

120196



C	REVISE ANCHOR NUT P/N SHEET 2-5	12.04.04
B	UPDATE FOR LSTC	09.10.09
A	NEW ISSUE	08.12.10
REV.	DESCRIPTION	BY DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE CALGARY, ALBERTA, CANADA
DRAWN		DRAWING NO. REV. C
CHECKED		D412-785-003-101 SHEET 1 OF 5
MFG. APPR.	N/A	TITLE SCALE
APPROVED		PAX SPKR MOUNT NTS
DE APPR.	N/A	
DATE	12.04.04	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR REPRODUCTION OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.

ITEM NO.	QTY. -201	PART NUMBER	DESCRIPTION
1	1	D412-785-003-401	PAX SPKR MOUNT, AFT
2	8	MS20426AD3(-4)	RIVET
3	4	MS21069L08	ANCHOR NUT






INSTALL MS21069L08 ANCHOR NUT  
USING MS20426AD3 RIVETS  
4 PL

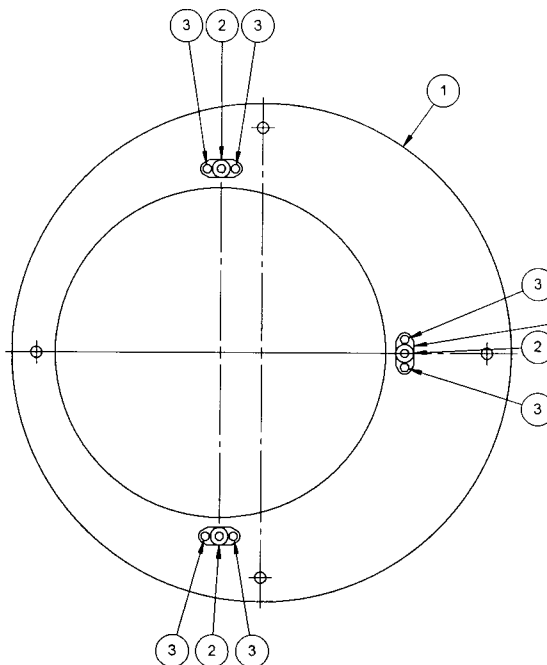
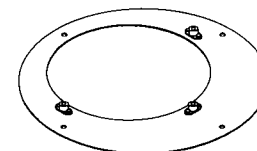
### D412-785-003-201 PAX SPEAKER MOUNT AFT


#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N D412-785-003-201 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.12 lbs

DESIGN	RN	<b>EAGLE COPTERS MAINTENANCE</b>	
DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	<b>D412-785-003-101</b>	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	<b>PAX SPKR MOUNT</b>	NTS
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ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-003-403	SPEAKER MOUNT, FWD
2	3	MS21069L08	ANCHOR NUT
3	6	MS20426AD3(-4)	RIVET






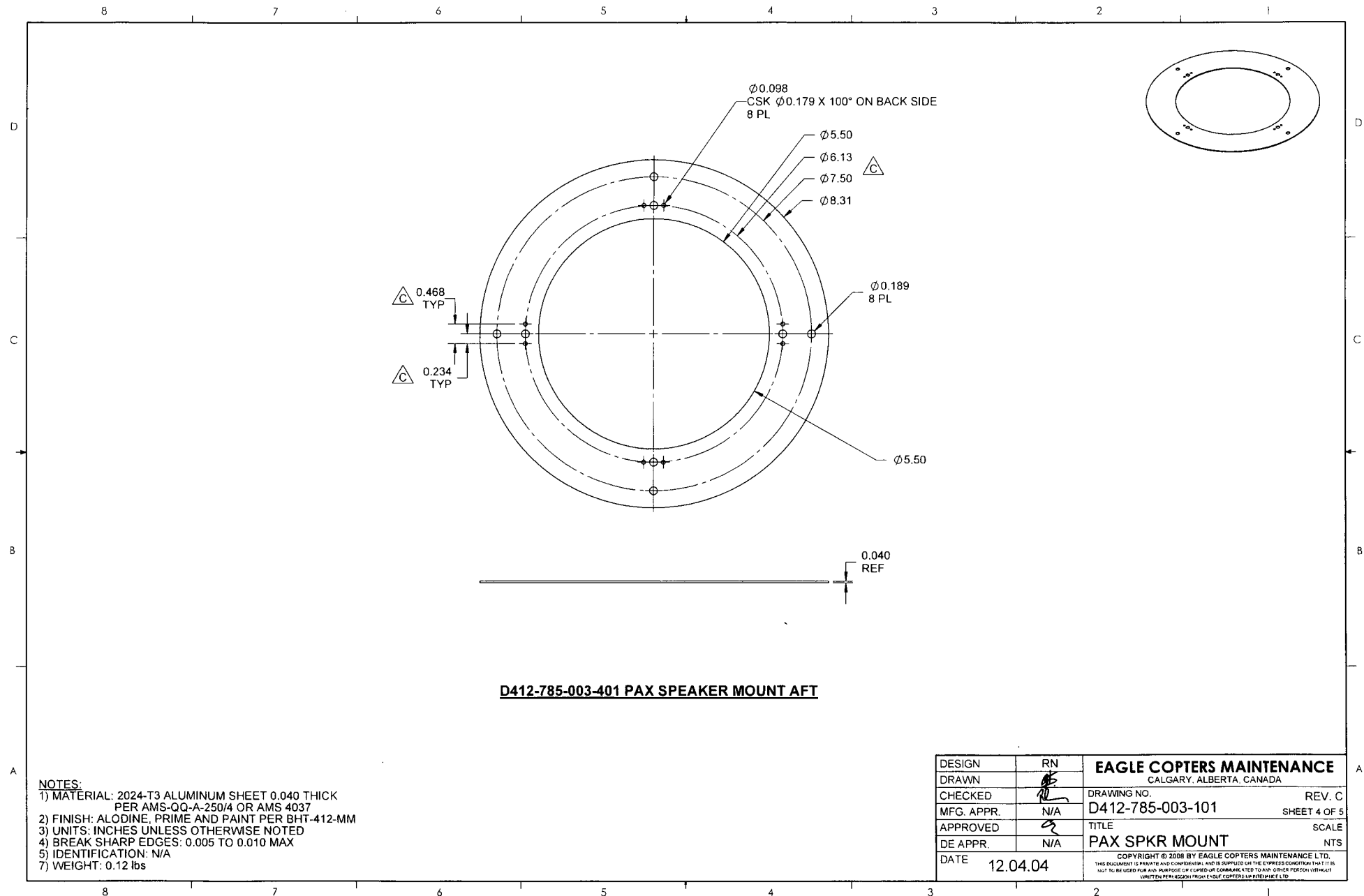
INSTALL MS21069L08 ANCHOR NUT   
USING MS20426AD3 RIVETS  
3 PL

**D412-785-003-203 PAX SPEAKER MOUNT FWD**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N "D412-785-003-203 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.05 lbs

DESIGN	RN	<b>EAGLE COPTERS MAINTENANCE</b>	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	<b>D412-785-003-101</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	<b>PAX SPKR MOUNT</b>	NTS
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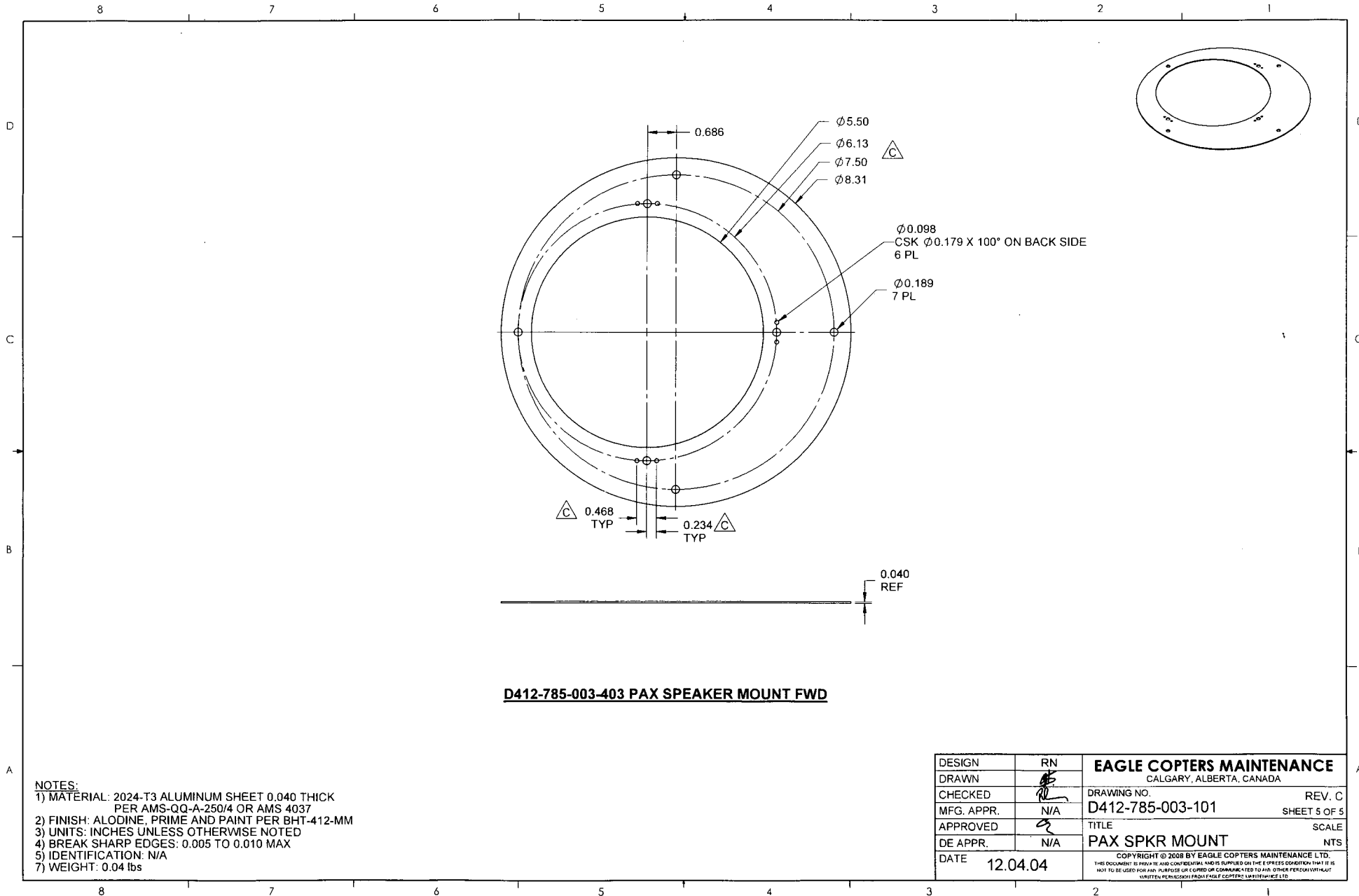


**D412-785-003-401 PAX SPEAKER MOUNT AFT**

- NOTES:  
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/4 OR AMS 4037  
2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM  
3) UNITS: INCHES UNLESS OTHERWISE NOTED  
4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
5) IDENTIFICATION: N/A  
7) WEIGHT: 0.12 lbs

DESIGN	RN	<b>EAGLE COPTERS MAINTENANCE</b> CALGARY, ALBERTA, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-785-003-101	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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DART AEROSPACE LTD

Work Order: 83884

Description: PAX SPEAKER MOUNT FWD

Part Number: D412-785-003-403

Inspection Dwg: Rev: PCF

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D412-785-003-403

# FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

X

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .099	+ .004 - .001	.099	2		V	B62
Ø .184	+ .005 - .001	.188	2		V	
.468	± .010	.470	2		V	
.234	± .010	.231	2		V	
Ø 5.50	+ .012 -	5.501	2		V	
Ø 6.13	+ .012 - .001	6.129	2		V	
Ø 7.50	+ .012 - .001	7.500	2		V	
Ø 8.31	+ .012 - .001	8.320	2		PROW502	
.686	± .010	.688	2		V	
.040	± .010	.042	2		V	

Measured by: B

Audited by: S

Prototype Approval:

Date: 12-4-06

Date: 12/4/06

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	